



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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RBW6205G03532-3G

Job Sheet 191333



Part No: RBW6205G03532-3G

Job Qty: 1 pcs

Part Name: Main Rotor Blade Trim Tab Tool



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/27/19

Job Tracking No:

Due Date: 4/26/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBW6205G03532-3G Rev.3 IPP Rev. A 18.10.10 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
95	Small Fab - 1	1 pcs	4/26/19	0.00	1.00		Small Fab - 1		DAS 71 9-89
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6	19-5-1	
							Small Fab - 7		
100	Small Fab - 2 - B4B	1 pcs	4/26/19	0.00	0.20		Small Fab - 1 - B4B		DAS 71 9-89
							Small Fab - 2 - B4B		
							Small Fab - 3 - B4B		
							Small Fab - 4 - B4B		
							Small Fab - 5 - B4B		
							Small Fab - 6 - B4B	19-5-1	
110	QC 5	1 pcs	4/26/19	0.00	0.00		QC 5 - 10		DAS 40 9-89
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		



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Container No: S177060



Part: RBW6205G03532-3G

Job No: 191333

Serial No/Batch: S177060

Revision: 3

Inspector:

Exp Date:

Instructions:

Date: 05/01/19

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130 Packaging 3-1 - Stock - B4B 1 pcs

4/26/19

0.00 0.00

Packaging 3 - 1 - B4B

Packaging 3 - 2 - B4B

Packaging 3 - 3 - B4B

Packaging 3 - 4 - B4B

Packaging 3 - 5 - B4B

Packaging 3 - 6 - B4B

Packaging 3 - 7 - B4B

Packaging 3 - 8 - B4B

Packaging 3 - 9 - B4B

Packaging 3 - 10 - B4B

Packaging 3 - 11 - B4B

Packaging 3 - 12 - B4B

Packaging 3 - 13 - B4B

Packaging 3 - 14 - B4B

Packaging 3 - 15 - B4B

Packaging 3 - 16 - B4B

Packaging 3 - 17 - B4B

Packaging 3 - 18 - B4B

Packaging 3 - 19 - B4B

Packaging 3 - 20 - B4B

Packaging 3 - 21 - B4B

Packaging 3 - 22 - B4B

Packaging 3 - 23 - B4B

Packaging 3 - 24 - B4B

Packaging 3 - 25 - B4B

Packaging 3 - 26 - B4B

Packaging 3 - 27 - B4B

Packaging 3 - 28 - B4B

Packaging 3 - 29 - B4B

Packaging 3 - 30 - B4B

Packaging 3 - 31 - B4B

Packaging 3 - 32 - B4B

Packaging 3 - 33 - B4B

Packaging 3 - 34 - B4B

Packaging 3 - 35 - B4B

Packaging 3 - 36 - B4B

140 QC 21 - FG

1 pcs

4/26/19

0.00 0.00

QC 21 - FG - 21

QC 21 - FG - 70

QC 21 - FG - 53

MAY 01 2019

DAG

21

9-89

DAG

21

9-89

MAY 01 2019

Part Op 95 - 1-Glue placard RBW6205G03532-3G-13 to RBW6205G03532-3G-11 foam as per DWG. 2-Glue foam to case and Descriptions: pack case as per DWG.

100 - 1-Glue placard RBW6205G03532-3G-13 to RBW6205G03532-3G-11 foam as per DWG. 2-Glue foam to case and pack case as per DWG.

110 - QC5- Inspect part completeness to step on W/O

130 - Identify as per dwg & Stock Location:

140 - QC21- Final Inspection - Work Order Release

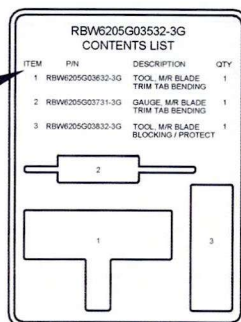
Job BOM

Part / Item	Component Name	Quantity	Operation	Container
APP-1550-E	Case	1 Ea (1 ea)	95-Small Fab - 1	5170623
RBW6205G03532-3G-11	Lid Foam use in case APP-1550-E	1 Ea (1 ea)	100-Small Fab - 2 - B4B	5170621
RBW6205G03532-3G-13	Inside Placard	1 pcs (1 ea)	100-Small Fab - 2 - B4B	5170622
RBW6205G03532-3G-9	Bottom Foam use in case APP-1550-E	1 Ea (1 ea)	100-Small Fab - 2 - B4B	5170622
RBW6205G03632-3G-PO	Main Rotor Trim Tab Bending Tool	1 Ea (1 ea)	100-Small Fab - 2 - B4B	5140738
RBW6205G03731-3G-PO	Trim Tab Bending Gauge Assembly	1 Ea (1 ea)	100-Small Fab - 2 - B4B	5140738
RBW6205G03832-3G-PO	Main Rotor Blade Blocking/Protecting Assembly	1 Ea (1 ea)	100-Small Fab - 2 - B4B	5138955

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
95-Small Fab - 1 100-Small Fab - 2 - B4B	APP-1550-E	1	13	0
	RBW6205G03532-3G-11	1	2	0
	RBW6205G03532-3G-13	1	0	0
	RBW6205G03532-3G-9	1	2	0
	RBW6205G03632-3G	1	0	0
	RBW6205G03731-3G	1	0	0
	RBW6205G03832-3G	1	0	0
Part Specifications				
Specifications could not be found.				

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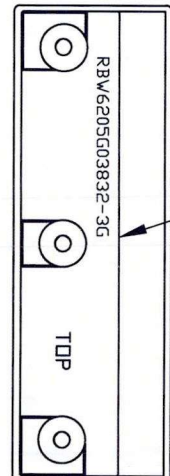
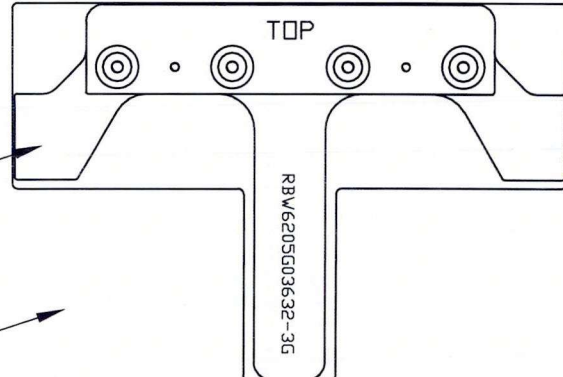
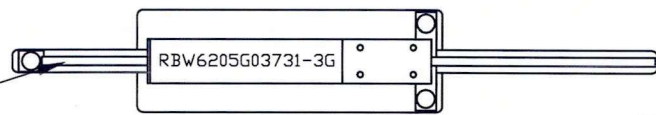


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-3

-1

-9



REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	ADDED WELDMENT AND RE-ORGANIZED PRINTS. CHANGED -2 & -3 THICKNESS FROM .394 TO .375, AND CHANGED -39 & -41 FROM #1.043 TO #1.00.	2/20/09	WP	
2	DELETED -5 RETAINER AND CHANGED -7 TO A BUY OUT. REMOVED COUNTER BORES FOR HEX HEAD SCREWS AND #10-32 HOLES FOR -5 RETAINER. CHANGED #1/4 HOLES TO 1/4-28 UNF. ALSO CHANGED -9 HEX SCREW TO STUD W/LOCTITE. ALSO CHANGED FROM POWDER COAT YELLOW TO PRIME AND PAINT.	5/12/09	WP	DW
2A	ADDED T/N TO INSIDE PLACARD, CH'D -13 FROM FOAM TOP TO INSIDE PLACARD, CH'D -11 FROM FOAM TOP TO LID FOAM, CH'D -11 CUTOUT TO RECESS FOR -13 PER R.W.	3/28/11	RJC	
2B	ADDED -3G TO ALL TOOL NUMBERS & ON -13 PER R.W.	5/11/11	RJC	RW
3	-9 CH'D DEPTH DIM WAS 4.00 IS 4.30, HEIGHT DIM WAS 5.25 IS 5.85. CORRECTED BOM. -11 ADDED CUTOUT FOR CLEARANCE, CH'D DEPTH OF PLACARD CUTOUT WAS .06 IS .125, CH'D SIZE OF PLACARD CUTOUT TO ACCOMODATE NEW SIZE, CH'D FOAM WAS C200 IS Y-20. -13 ADDED PLACEMENT DIAGRAM TO PLACARD.	2/7/13	BIM	JG

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WITHOUT NOTICE
WORK ORDER

NO. 191333 MLS
19-02-27

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NOTES

1. RBW6205G03532-3G KIT CONTAINS THREE TOOLS, NUMBERED RBW6205G03632-3G AND RBW6205G03731-3G AND RBW6205G03832-3G.
2. FUNCTION: USED FOR MAIN ROTOR BLADE TRIM TAB BENDING.

ORIGINAL No. REF.

KIT No.	TOOL No.	ORIGINAL No.
RBW6205G03532	≡ RBW6205G03532-3G	≡ 3G6205G03632
RBW6205G03532	≡ RBW6205G03632-3G	≡ 3G6205G03632
RBW6205G03532	≡ RBW6205G03731-3G	≡ 3G6205G03731
RBW6205G03532	≡ RBW6205G03832-3G	≡ 3G6205G03832

DO NOT USE, FOR REFERENCE ONLY.

RED BARN MACHINE	
TITLE MAIN ROTOR BLADE TRIM TAB TOOL KIT	
DWG NO. RBW6205G03532-3G	REV 3
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 XX ± .01 X ± .1	DRAWN BY: MARTINEZ APPROVED: <i>D Weil</i> HEAT TREAT FINISH SPEC USED ON MODEL AW139 REF. 3G6205G03532
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	SCALE NTS DATE 1/15/09 SHEET 1 of 4

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					